

Work Order ID 131498

April-13-15 8:37:38 AM

131498

Page 1

Item ID: D5160-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 4/13/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/14/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5160

A

110

0.00

110

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

(14)

DC 15/04/14

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(14)

DC 15/04/14

130

0.00

130

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(14)

DAS
30
0.00

APR 15 2015

Work Order ID 131498

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Item ID: D5160-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 4/13/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/14/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140	NC BRAKE					<u>14</u>	<u>FF</u>		APR 16 2015
Small Fab	Memo	0.00							
Small Fab	C'SINK HOLES AS PER DWG								
150		0.00							DAS 38 9-89
150	QC5- Inspect part completeness to step on W/O					<u>(14)</u>			
QC	Memo	0.00							
Quality Control									APR 17 2015
160		0.00							
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3								
Powdercoat	<u>M 130746.</u>	0.00							
Powder Coating	Memo					<u>14</u>	<u>d 15-4-20.</u>		DAS 34 9-89
	START TIME: <u>11:05</u>								
	OVEN TEMPERATURE: <u>320°</u>								
	FINISH TIME: <u>11:35</u>								

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

RS.4-2

Picklist Print

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Work Order ID: 131498

131498

Parent Item: D5160-5

D5160-5

Parent Item Name: Shim

Start Date: 4/13/15

Required Date: 4/14/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 14.10.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S188		Purchased			No		sf	179.0000		1			
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M304S188

304 SHEET 0.188

DL 15/04/14

Location

Loc Qty

Loc Code

MAT020

179

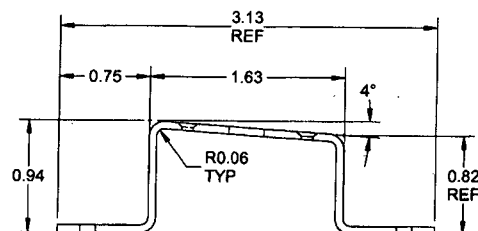
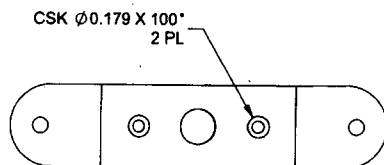
113216

96

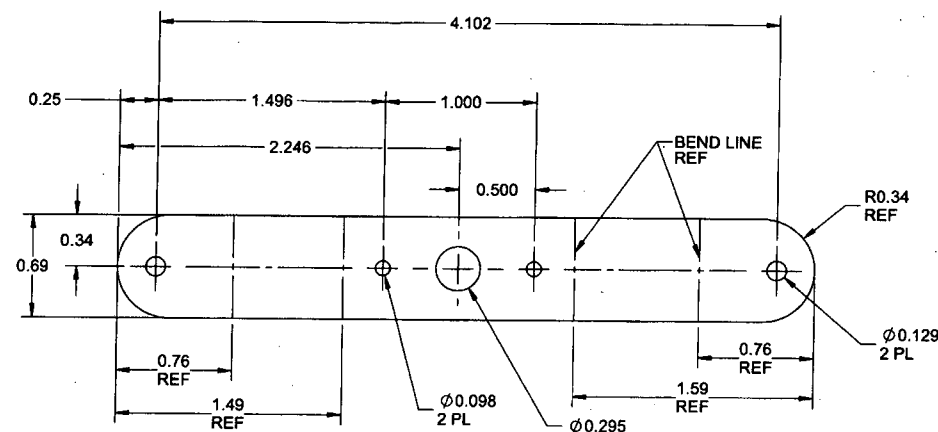
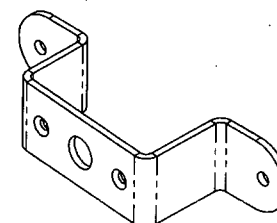
M130454

83

17



D5160-1 SEAT BRACE BRACKET
(MAKE FROM D5160-1F)



D5160-1F SEAT BRACE BRACKET
(FLAT PATTERN)

NOTES:

- 1) MATERIAL -1F: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
-1: MAKE FROM -1F
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5160-1" AND B/N BXXXXX
PER DART QSI 044 6.7.
- 7) WEIGHT: 0.05 lbs

RELEASED

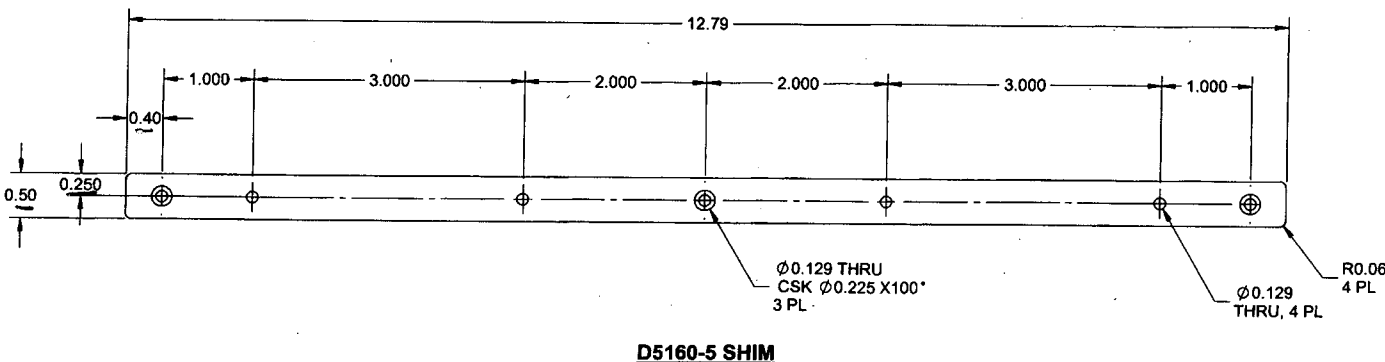
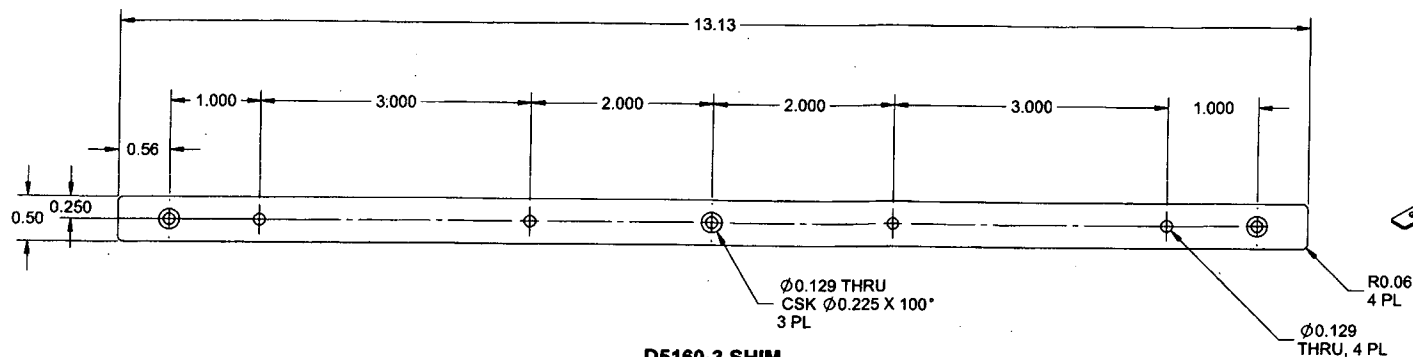
2015 FEB 04

EN 15-522 4P

APPROVED

A	NEW ISSUE	AJS	14.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5160	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SHEET METAL PARTS 350 SEAT	NTS
DATE	14.09.25	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



NOTES:

1) MATERIAL -3: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA

-5: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.188 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S7GA

2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5160-X" AND B/N BXXXXX
PER DART QSI 044 6.7

7) WEIGHT -3: 0.12 lbs
-5: 0.34 lbs

RELEASED

2015 FEB 04

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5160	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
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8 7 6 5 4 3 2 1